

Work Order ID 145978 *Split*

Thursday, May 12, 2016 8:03:46 AM

\*145978\*

Page 1

Item ID: D3307-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Access Panel Assy LH

Start Date: 4/28/2016 Start Qty: ~~400~~ *2*

\*4\*

Cust Item ID:

Required Date: 5/5/2016 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan: *[Signature]*

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr             |                      |         |        |              |               |               |                  |                |
| D3307                          | Rev C                    |                      |         |        |              |               |               |                  |                |

100

\*100\*

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

0.00

Memo

0.72

1-Cut D3307-1 as per Dwg D3307 Dwg Rev: *C*

Prog Rev: *C*

2-Deburr if necessary

110

\*110\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.04

DAS  
50

*6* *06/08/2016*

*VP 06/07/2016*





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Thursday, May 12, 2016 8:03:46 AM

\*145978\*

Page 3

Item ID: D3307-041

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Access Panel Assy LH

Stop

\*NS2\*

Start Date: 4/28/2016

Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 5/5/2016

Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description                           | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp    |
|--------------------------------|----------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|-------------------|
| 150                            | QC5- Inspect part completeness to step on W/O      | 0.00                 |         |        |              |               |               |                  | DAS<br>38<br>9-89 |
| *150*                          |                                                    |                      |         |        |              |               |               |                  |                   |
| QC                             | Memo                                               | 0.08                 |         |        |              |               |               |                  |                   |
| Quality Control                |                                                    |                      |         |        |              |               |               |                  | JUN 2 2 2016      |
| 160                            | Identify as per dwg & Stock Location: <u>Sto31</u> | 0.00                 |         |        |              |               |               |                  |                   |
| *160*                          |                                                    |                      |         |        |              |               |               |                  |                   |
| Packaging                      | Memo                                               | 0.04                 |         |        |              |               |               |                  |                   |
| Packaging                      |                                                    |                      |         |        |              |               |               |                  | JUN 2 3 2016      |
| 170                            | QC21- Final Inspection - Work Order Release        | 0.00                 |         |        |              |               |               |                  |                   |
| *170*                          |                                                    |                      |         |        |              |               |               |                  |                   |
| QC                             | Memo                                               | 0.40                 |         |        |              |               |               |                  |                   |
| Quality Control                |                                                    |                      |         |        |              |               |               |                  | JUN 2 4 2016      |

MW JUN 2 4 2016

# Picklist Print

Page 1

Thursday, May 12, 2016 8:03:45 AM

Work Order ID: 145978

**\*145978\***

Parent Item: D3307-041

**\*D3307-041\***

Parent Item Name: Access Panel Assy LH

Start Date: 4/28/2016

Required Date: 5/5/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A08.08.05New issue EC verified by:DD IPP REV:B  
12.11.07 AS PER DWG REV.C DD VERF:JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit     | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-----------------|--------------|---------------|----------------|--------|
| D3307-3                         |                        | Manufactured  | No          |                     |                  | 140             | Each               | 4.0000         | 1               | 4            |               |                |        |
| <b>*D3307-3*</b>                |                        |               |             |                     |                  |                 |                    |                | <b>**</b>       |              |               |                |        |
| Gasket                          |                        |               |             |                     |                  |                 |                    |                |                 |              |               |                |        |
|                                 |                        |               |             |                     | <u>Location</u>  |                 |                    | <u>Loc Qty</u> | <u>Loc Code</u> |              |               |                |        |
|                                 |                        |               |             |                     | GA               |                 |                    | 4              |                 | 2            |               |                |        |
|                                 |                        |               |             |                     | 126293           |                 |                    | 4              |                 | 4            |               |                |        |
| M304S22GA                       |                        | Purchased     | No          |                     |                  | 100             | SF                 | 135.0750       | 0.26            | 1.04         |               |                |        |
| <b>*M304S22GA*</b>              |                        |               |             |                     |                  |                 |                    |                | <b>**</b>       |              |               |                |        |
| 304/316 .032 Sheet              |                        |               |             |                     |                  |                 |                    |                |                 |              |               |                |        |
|                                 |                        |               |             |                     | <u>Location</u>  |                 |                    | <u>Loc Qty</u> | <u>Loc Code</u> |              |               |                |        |
|                                 |                        |               |             |                     | MAT020           |                 |                    | 135.075        |                 |              |               |                |        |
|                                 |                        |               |             |                     | m126593          |                 |                    | 28.475         |                 |              |               |                |        |
|                                 |                        |               |             |                     | m131999          |                 |                    | 42.6           |                 |              |               |                |        |
|                                 |                        |               |             |                     | m134399          |                 |                    | 64             |                 |              |               |                |        |

JUN 22 2016

FF

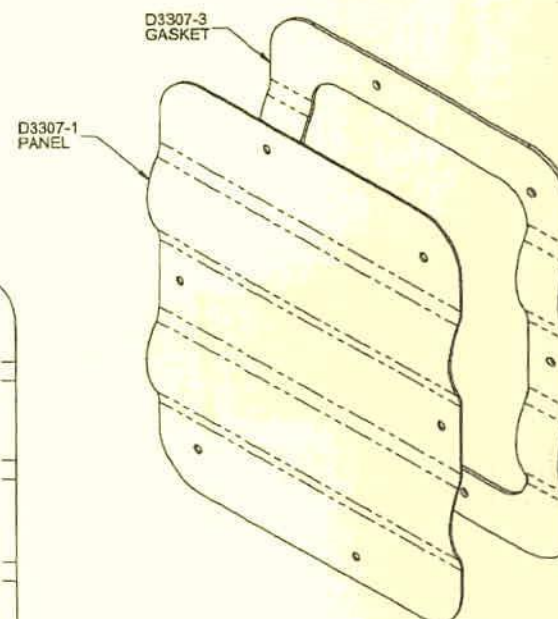
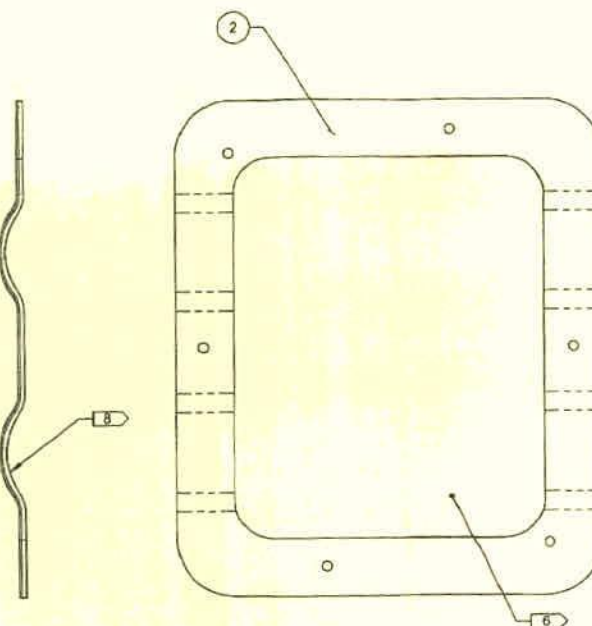
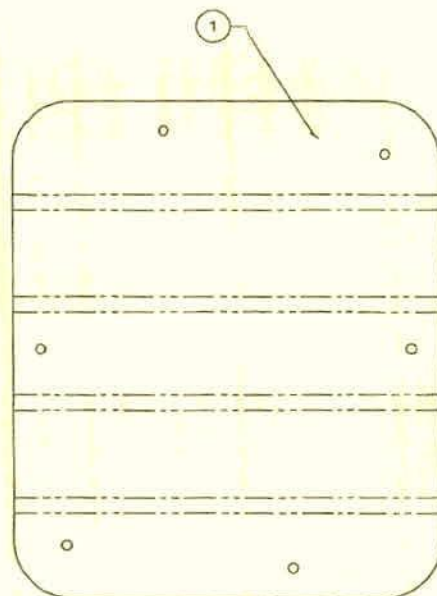
OK 1 PR 06/07/2016

1.7





| ITEM | QTY | P/N       | DESCRIPTION       |
|------|-----|-----------|-------------------|
|      | X   | D3307-041 | ACCESS PANEL ASSY |
| 1    | 1   | D3307-1   | PANEL             |
| 2    | 1   | D3307-3   | GASKET            |



**D3307-041 ACCESS PANEL ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3307-041" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.39 lbs
- 8) INSTALL GASKET ON THIS SIDE USING 3M SCOTCH-GRIP ADHESIVE P/N 1300/1300L IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

RELEASED  
2012-11-06  
w/o

|            |                                                                                                                                                          |    |          |
|------------|----------------------------------------------------------------------------------------------------------------------------------------------------------|----|----------|
| C          | CHANGED MATERIAL FOR D3307-3. REASON: PROCUREMENT, REF CAR12-69.                                                                                         | MB | 12.10.17 |
| B          | - MOVE TWO DIAGONAL CORNER HOLES TO ELIMINATE INTERFERENCE AT INSTALLATION POINT.<br>- CORRECTED FLAT PATTERN OVERALL LENGTH (C4-3)<br>- REF: PAR 12-165 | RP | 1204.11  |
| A          | NEW ISSUE                                                                                                                                                | RF | 0409.23  |
| REV.       | DESCRIPTION                                                                                                                                              | BY | DATE     |
| DESIGN     |                                                                                                                                                          |    |          |
| DRAWN      |                                                                                                                                                          |    |          |
| CHECKED    |                                                                                                                                                          |    |          |
| MFG. APPR. |                                                                                                                                                          |    |          |
| APPROVED   |                                                                                                                                                          |    |          |
| DE APPR.   |                                                                                                                                                          |    |          |
| DATE       | 12.10.17                                                                                                                                                 |    |          |

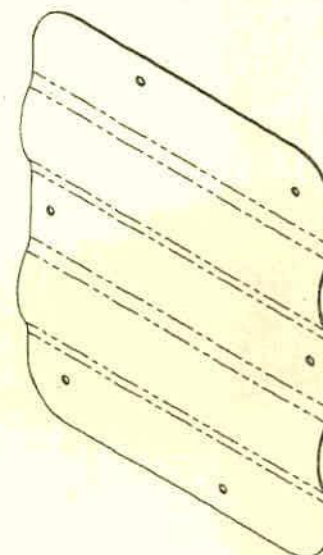
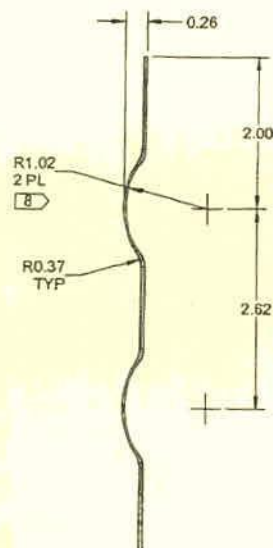
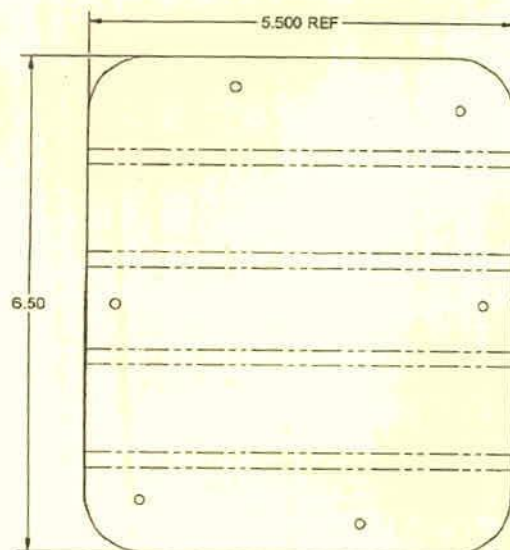
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3307 REV. C  
SHEET 1 OF 4  
TITLE ACCESS PANEL ASSY SCALE NTS

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w/o 145978

dm 16/05/06



**D3307-1 PANEL**

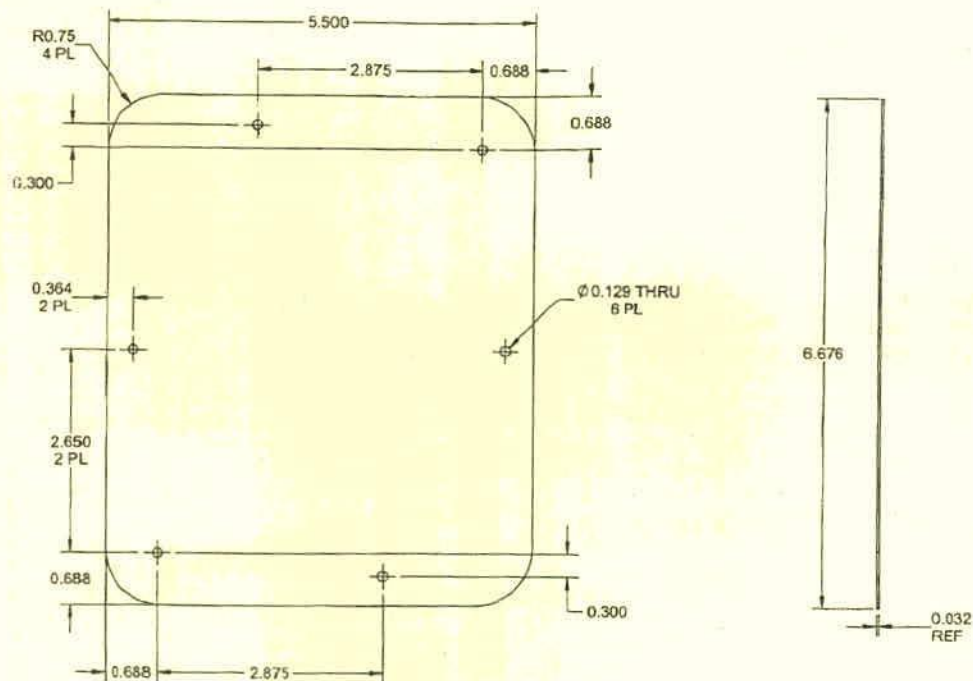
**NOTES:**

- 1) MATERIAL: MAKE FROM D3307-1F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs
- 8) FORM USING DT8745

**RELEASED**  
2012-11-06  
JAN

|            |          |                                                                                                                                                                                                                                                                                          |              |
|------------|----------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     |          | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                                |              |
| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                              |              |
| CHECKED    |          | DRAWING NO.                                                                                                                                                                                                                                                                              | REV. C       |
| MFG. APPR. |          | D3307                                                                                                                                                                                                                                                                                    | SHEET 2 OF 4 |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                                                    | SCALE        |
| DE APPR.   |          | ACCESS PANEL ASSY                                                                                                                                                                                                                                                                        | NTS          |
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**D3307-1F PANEL (FLAT PATTERN)**

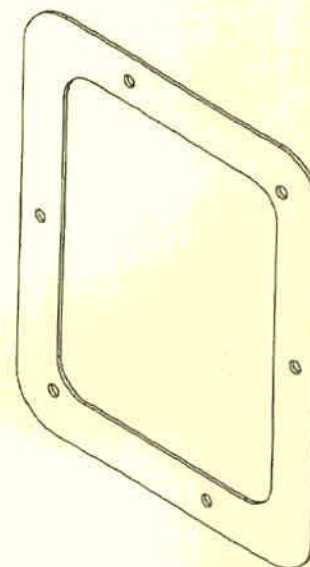
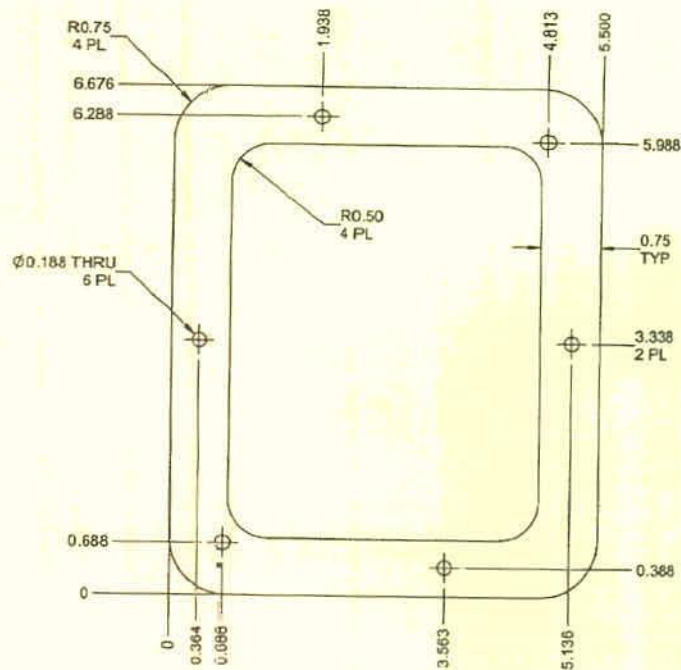
**NOTES:**

- 1) MATERIAL: AISI 304/316 SS, ANNEALED, 2B FINISH, 0.032 THICK  
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240  
OR ASME SA240. (REF. M304S22GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

|            |          |                                        |              |
|------------|----------|----------------------------------------|--------------|
| DESIGN     | JE       | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN      | JE       | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED    | JE       | DRAWING NO.                            | REV. C       |
| MFG. APPR. | JE       | D3307                                  | SHEET 3 OF 4 |
| APPROVED   | JE       | TITLE                                  | SCALE        |
| DE APPR.   | JE       | ACCESS PANEL ASSY                      | NTS          |
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**RELEASED**  
2012-11-06





**D3307-3 GASKET**

**RELEASED**  
2012-11-06

- NOTES:**  
 1) MATERIAL: THERMO-CHEM P/N G-89, 0.060 THICK  
 POSSIBLE SUPPLIER: A.R. THOMSON GROUP  
 2) FINISH: N/A  
 3) TOLERANCES: ALL DIMENSIONS FOR D3307-3 ARE +/- 0.02 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.06 lbs

|            |          |                                                          |                                                                                                                                                                                                                                                                         |              |
|------------|----------|----------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     |          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                                                                                                                                                                                                                                                                         |              |
| DRAWN      |          |                                                          |                                                                                                                                                                                                                                                                         |              |
| CHECKED    |          |                                                          | DRAWING NO.                                                                                                                                                                                                                                                             | REV. C       |
| MFG. APPR. |          |                                                          | D3307                                                                                                                                                                                                                                                                   | SHEET 4 OF 4 |
| APPROVED   |          |                                                          | TITLE                                                                                                                                                                                                                                                                   | SCALE        |
| DE APPR.   |          |                                                          | ACCESS PANEL ASSY                                                                                                                                                                                                                                                       | NTS          |
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